



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

646.9701

Job Sheet 212179



Part No: 646.9701

Job Qty: 5 pcs

Part Name: Cutter Sub Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/20

Job Tracking No:

Due Date: 8/31/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 646.9701 REV.J IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS IPP REV :B AS PER REV D 16-03-07  
JLM VERIFIED BY:JFS IPP REV:C 2020.05.27 AS PER DWG REV.J DD VERF:JFS

Ship Via:

## Bill of Materials

## Job Routing

| Op<br>No | Operation              | Qty      | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign-off |
|----------|------------------------|----------|------------|-------------|--------------|------------|-----------------------|-----------|----------|
|          |                        |          |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |          |
| 110      | Packaging 1 - Pick Kit | 5<br>pcs |            | 8/29/20     | 0.00         | 0.00       | Packaging 1 - 1       |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 2       |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 3       |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 4       |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 5       |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 6       |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 7       |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 8       |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 9       |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 10      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 11      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 12      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 13      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 14      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 15      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 16      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 17      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 18      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 19      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 20      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 21      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 22      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 23      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 24      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 25      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 26      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 27      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 28      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 29      |           |          |
|          |                        |          |            |             |              |            | Packaging 1 - 30      |           |          |

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Container No: S296543



Part: 646.9701

Job No: 212179

Serial No/Batch: S296543

Revision: REV.J

Inspector:

Exp Date:

Instructions:

Date: 08/27/20

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|     |                             |          |         |           |                             |  |
|-----|-----------------------------|----------|---------|-----------|-----------------------------|--|
|     |                             |          |         |           | Packaging 1 - 31            |  |
|     |                             |          |         |           | Packaging 1 - 32            |  |
|     |                             |          |         |           | Packaging 1 - 33            |  |
|     |                             |          |         |           | Packaging 1 - 34            |  |
|     |                             |          |         |           | Packaging 1 - 35            |  |
|     |                             |          |         |           | Packaging 1 - 36            |  |
|     |                             |          |         |           | Packaging 1 - 37            |  |
|     |                             |          |         |           | Small Fab - 1 - B4B         |  |
|     |                             |          |         |           | Small Fab - 2 - B4B         |  |
|     |                             |          |         |           | Small Fab - 3 - B4B         |  |
| 120 | Small Fab - 2 - B4B         | 5<br>pcs | 8/31/20 | 0.00 2.00 | Small Fab - 4 - B4B         |  |
|     |                             |          |         |           | Small Fab - 5 - B4B         |  |
|     |                             |          |         |           | Small Fab - 6 - B4B         |  |
|     |                             |          |         |           | Small Fab - 7 - B4B         |  |
|     |                             |          |         |           | Small Fab - 8 - B4B         |  |
|     |                             |          |         |           | Small Fab - 9 - B4B         |  |
|     |                             |          |         |           | Small Fab - Various 1 - B4B |  |
|     |                             |          |         |           |                             |  |
|     |                             |          |         |           |                             |  |
|     |                             |          |         |           |                             |  |
| 130 | QC 5                        | 5<br>pcs | 8/31/20 | 0.00 0.00 | QC 5 - 10                   |  |
|     |                             |          |         |           | QC 5 - 12                   |  |
|     |                             |          |         |           | QC 5 - 17                   |  |
|     |                             |          |         |           | QC 5 - 18                   |  |
|     |                             |          |         |           | QC 5 - 19                   |  |
|     |                             |          |         |           | QC 5 - 22                   |  |
|     |                             |          |         |           | QC 5 - 24                   |  |
|     |                             |          |         |           | QC 5 - 3                    |  |
|     |                             |          |         |           | QC 5 - 43                   |  |
|     |                             |          |         |           | QC 5 - 49                   |  |
| 140 | Packaging 3-1 - Stock - B4B | 5<br>pcs | 8/31/20 | 0.00 0.00 | QC 5 - 51                   |  |
|     |                             |          |         |           | QC 5 - 58                   |  |
|     |                             |          |         |           | QC 5 - 68                   |  |
|     |                             |          |         |           | QC 5 - 9                    |  |
|     |                             |          |         |           | QC 5 - 50                   |  |
|     |                             |          |         |           | QC 5 - 30                   |  |
|     |                             |          |         |           | QC 5 - 40                   |  |
|     |                             |          |         |           | QC 5 - 61                   |  |
|     |                             |          |         |           | QC 5 - 81                   |  |
|     |                             |          |         |           | QC 5 - 82                   |  |
|     |                             |          |         |           | Packaging 3 - 1 - B4B       |  |
|     |                             |          |         |           | Packaging 3 - 2 - B4B       |  |
|     |                             |          |         |           | Packaging 3 - 3 - B4B       |  |
|     |                             |          |         |           | Packaging 3 - 4 - B4B       |  |
|     |                             |          |         |           | Packaging 3 - 5 - B4B       |  |
|     |                             |          |         |           | Packaging 3 - 6 - B4B       |  |
|     |                             |          |         |           | Packaging 3 - 7 - B4B       |  |
|     |                             |          |         |           | Packaging 3 - 8 - B4B       |  |
|     |                             |          |         |           | Packaging 3 - 9 - B4B       |  |
|     |                             |          |         |           | Packaging 3 - 10 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 11 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 12 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 13 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 14 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 15 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 16 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 17 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 18 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 19 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 20 - B4B      |  |
|     |                             |          |         |           | Packaging 3 - 21 - B4B      |  |
|     |                             |          |         |           |                             |  |
|     |                             |          |         |           |                             |  |
|     |                             |          |         |           |                             |  |
|     |                             |          |         |           |                             |  |
|     |                             |          |         |           |                             |  |
|     |                             |          |         |           |                             |  |
|     |                             |          |         |           |                             |  |
|     |                             |          |         |           |                             |  |
|     |                             |          |         |           |                             |  |

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|                |          |         |           |                        |                   |
|----------------|----------|---------|-----------|------------------------|-------------------|
|                |          |         |           | Packaging 3 - 22 - B4B |                   |
|                |          |         |           | Packaging 3 - 23 - B4B |                   |
|                |          |         |           | Packaging 3 - 24 - B4B |                   |
|                |          |         |           | Packaging 3 - 25 - B4B |                   |
|                |          |         |           | Packaging 3 - 26 - B4B |                   |
|                |          |         |           | Packaging 3 - 27 - B4B |                   |
|                |          |         |           | Packaging 3 - 28 - B4B |                   |
|                |          |         |           | Packaging 3 - 29 - B4B |                   |
|                |          |         |           | Packaging 3 - 30 - B4B |                   |
|                |          |         |           | Packaging 3 - 31 - B4B |                   |
|                |          |         |           | Packaging 3 - 32 - B4B |                   |
|                |          |         |           | Packaging 3 - 33 - B4B |                   |
|                |          |         |           | Packaging 3 - 34 - B4B |                   |
|                |          |         |           | Packaging 3 - 35 - B4B |                   |
|                |          |         |           | Packaging 3 - 36 - B4B |                   |
|                |          |         |           | Packaging 3 - 37 - B4B |                   |
| 150 QC 21 - SA | 5<br>pcs | 8/31/20 | 0.00 0.00 | QC 21 - SA - 21        |                   |
|                |          |         |           | QC 21 - SA - 70        |                   |
|                |          |         |           | QC 21 - SA - 9         | DAS<br>21         |
|                |          |         |           | QC 21 - SA - 77        | DAS<br>28<br>9-89 |

Part Op 110 - (Pick Kit)  
 Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note . A/R RTV LOCTITE  
 598: S286038 exp. date: 12/21  
 130 - (QC5- Inspect part completeness to step on W/O)  
 140 - (Identify as per dwg & Stock Location: CC107) \*\*\*IDENTIFY AS PER IAW MPP-120\*\*\*  
 150 - (QC21- Final Inspection - Work Order Release)

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| Job BOM       |                   |               |                            |                               |
|---------------|-------------------|---------------|----------------------------|-------------------------------|
| Part / Item   | Component Name    | Quantity      | Operation                  | Container                     |
| 646.9710      | Body              | 5 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | <u>3270828</u>                |
| 646.9711      | Blade             | 10 pcs (2 ea) | 110-Packaging 1 - Pick Kit | <u>326/580</u>                |
| MS21042L08    | Nut               | 30 Ea (6 ea)  | 110-Packaging 1 - Pick Kit | <u>3265471</u>                |
| MS27039-08-19 | Screw             | 30 Ea (6 ea)  | 110-Packaging 1 - Pick Kit | <u>4x 3250577-26x 3285458</u> |
| NAS1149FN832P | Washer (AN960-8 ) | 60 Ea (12 ea) | 110-Packaging 1 - Pick Kit | <u>3248080</u>                |

| Job Allocations            |                |          |           |           |
|----------------------------|----------------|----------|-----------|-----------|
| Operation                  | Component Part | Required | Inventory | Allocated |
| 110-Packaging 1 - Pick Kit | 646.9710       | 5        | 28        | 0         |
|                            | 646.9711       | 10       | 32        | 0         |
|                            | MS21042L08     | 30       | 795       | 0         |
|                            | MS27039-08-19  | 30       | 548       | 0         |
|                            | NAS1149FN832P  | 60       | 1,361     | 0         |

| Part Specifications                |  |
|------------------------------------|--|
| Specifications could not be found. |  |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                      |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  | QC / QA Coordinator    |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex;"> <div style="flex: 1;">           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Presservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex;"> <div style="flex: 1;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="flex: 1;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="flex: 1;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |